0.00

Memo

Quality Control

									DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-C	CONFORM	MANCE / UPD		QA Closed:	Date:	
Work Ord	or:				DISPOSITION			AGAINST DE			
Part NCR	No				Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ł	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Actio	on	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						•					3
						AULT CATE	GORY				
Landi	Cracks Crushed	Not Conce		O/S	General Bend BOM/Route Broken/Damaged Burrs	Instruct	on Incomplete ions Incomplete/Ur		Ovalized Over/Under Part Incorre Part Lost/M	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
I	Cuffs		- 1	Contamination Maintenance				Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 92992 Tuesday, November 13, 2012 10:40:15 AM Item ID: D350-766-021 Accept *N900040100* Setup Start **Revision ID:** Interior Protector (Aft Baggage Protector) **Item Name:** Start Oty: 2.00 **Start Date:** 11/13/2012 **Cust Item ID:** Req'd Qty: 2.00 **Required Date:** 11/22/2012 **Customer:** Reference: Run **Approvals: Process Plan:** Tooling: Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Work Center ID **Description** Qty Qty **Run Hours** Code Number 130 0.00 *120* Packaging 0.00 Memo Identify and pack for shipping as per PPP D350-766-021 Location: Packaging

0.00

0.00

PPP Rev:

Memo

QC21- Final Inspection - Work Order Release

140

QC

1/10

Quality Control

MC 12-11-30

Insp.

Stamp

Page 2

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Date:	
Work Ord	er:		·			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	•				,	Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR 1	No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier	Other
Root					Descri	ption of work order update	lni	itial	Ac	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chie	f Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													1.
Training		•											
Unapproved													
						F	AULT	CATE	GORY				
Landi	ng G	ear				General					_		_
		Bending				Bend	∐_G	irain			Ovalized		Pressure/Forced
	'	Centre No	t Concer	ntric to (o/s	BOM/Route	Шн	ardwa	re		Over/Under	tolerance	Temperature/Cure
	<u></u>	Cracks				Broken/Damaged	L In	ıspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/C	Crimped.			Burrs	In	struct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	\^	/lainte	nance		Part Moved		
		Heat Trea	t .			Countersink	\square N	1islabe	led		Positioned V	Vrong	_
		Inspection	Strip in	Tube		Cut Too Short	\square N	1isread	I		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	o	ffset					
		Torque W	aves in E	xtrusion	۱ 🗌	Drawing	o	ut of C	Calibration				
	-	Turning Se	equence			Finish		ut of S	equence				
ſ	Wave/Twist in Tube		Folio	По	Outside Dimensions								

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

Tuesday, November 13, 2012 10:40:14 AM

Work Order ID:

92992

Work Order ID:	92992								*				4
Parent Item:	D350-766-021							Sta	rt Date: 11/13/	2012	Required	Date: 11/2	2/2012
Parent Item Name:	Interior Protector (A	Aft Baggage Protec	tor)					St	art Qty: 2.00	7	Required	Qty: 2.00	
Comments:	IPP RevA: New iss	sue DD verified by:	EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3889-041		Manufactured	No			110	Each	1.0000	- 5	2		ند در	
Panel, Floor									, ,	- A -	720		10 9 T
24	6 5			Location		Loc Oty	<u>L</u>	oc Code		93	415	(Z)	
	• •			FG		1							
D3890-041		Manufacturad	No	864	127	110	Each	0.0000	(Z				
	16	Manufactured	110			110	Each	0.0000	(A)	7 -	9205	7 /	
D3891-041	-	Manufactured	No			110	Each	2.0000	()	- 1.			
Panel, Fwd LH									<u> </u>	Time a section of the section is	na wasangaya	A ALLEY MAN ANDRESS	
Smo				Location		Loc Oty	<u>L</u>	oc Code					
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D3891=042		Manufactured	No	920	770	110	Each	2.0000	1	1.4			<i>•</i> • • • • • • • • • • • • • • • • • •
Panel, Fwd-RH		Manufactured						2.0000	``	# ·	17 2	0	2/ 5 V
• •				Location		Loc Qty	Le	oc Code				_	•
Sm)				st151		2			<u> </u>		_		
D2044.1				921	00	2			73	1/00	1 0		2
—D3944-1		Manufactured	No			110	Each	14.0000		Þ		A	
				Location		Loc Qty	L	oc Code	- .	201		restauration, commence of	
Sim				ST075		14	<u>r</u>	oc Code			,		
				507	85	4	•		حی	0780			₽
_				921	04	10			V			1	<i>\$</i> }
D3945-041 Bracket		Manufactured	No			110	Each	9.0000	13	84			14/13 (1)
				Location		Loc Oty	La	oc Code	ser o⊷ ts, ⊸s	rathal dha			
				ST075		9	20		_				
5M2				877	22	9			8	7722			

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

									QA Closed:	Date:	
Work Ord	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part I	No				Rework Scrap Use-as-is Work Order Update	-{	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Actio	on	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material											
											•
Setup		l									
Other Process		ļ									
Supplier	\dashv										
Training						}					
Unapproved							· ·				
Onapproved			.j !		F	AULT CATE	LGORY				1
Landii	ng Gear				General	1021 07112					
	Bendin	g			Bend	Grain			Ovalized		Pressure/Forced
		Not Conce	ntric to (o/s -	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorred	ct	Weld
	Crushe	d/Crimped.			Burrs	Instruct	ions Incomplete/Un	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		_
[Heat Ti	eat			Countersink	Mislabe	eled		Positioned V	Vrong	_
•	Inspect	ion Strip in	Tube		Cut Too Short	Misread	t		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes	Offset				<u></u>	
	Torque	Waves in E	xtrusion	١ [Drawing	Out of 0	Calibration				
	Turning	Sequence			Finish	Out of S	Sequence				
	Wave/	wist in Tub	e		Folio	Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



Tuesday, November 13, 2012 10:40:14 AM

Work Order ID:

92992

Parent Item:

D350-766-021

Parent Item Name:

Interior Protector (Aft Baggage Protector)

Manufactured

Location

81016

86347

ST075

ST077

Start Date: 11/13/2012

Required Date: 11/22/2012

Start Oty: 2.00

Required Oty: 2.00

D3948-041 Plate, Anchor

N525-10R7

110

Loc Qty

2

6

6

8.0000

Loc Code

Purchased

No

110

Each

Each

3,302.0000

Loc Code

Location Loc Qty ST344 3292 123248 900 123355 392 123522 500 123603 1500 ST345 115371 120833

121390

Each

82.0000

Loc Code

Screw

Purchased

Purchased

No

No

Loc Qty 82 82 122378

110

110

Loc Qty

Each 146.0000

CCR264SS3*2

ST327

Location

Location

ST343

146 106578 96 108738 2 112314 48 Loc Code

											DQA:	Date	2:
NCR:	Yes	/ No				WORK ORDER NON-C	COI	VFORI	MANCE / UPI	DATE	QA Closed:	Date	·
				•		DISPOSITION				AGAINST DE	PARTMENT		
Work Ord	er:						,		·		· · · · · · · · · · · · · · · · · ·	_	
Part	No.					Rework Scrap Use-as-is		f	Skid-tube Machining noforming	Crosstube Small Fab Finishing	⊣	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR	No.	ATUF.				Work Order Update]		Large Fab	Composite]	Supplier	
Root Cause		Date	Step	Qty	Desc	otion of work order update		nitial ief Eng	Act	ion iption	Sign & Date	Verification	QC Inspector
oc/Data	T		Jeep	α.,		 Tron comornance	-	iici Liig	0 (30)	TP COT	Dute	· criticación	- Compositor
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perator	\vdash												
1aterial													
etup	┝												
ther													
rocess	\vdash												
upplier													
raining													
napproved	_						Ì						
			•			 F	AUL	T CATE	SORY				
Landi	ng (Gear				 General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			ſ	Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
		Crushed/0	Crimped.		Γ	Burrs		Instructi	ons Incomplete/L	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	_	
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
		Inspection	Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
Frank Const		Ripples in	Bend			Drill Holes		Offset					
	Torque Waves in Extrusion Drawing			Out of Calibration									
		Turning Se	equence		ſ	Finish		Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, November 13, 2012 10:40:14 AM

Work Order ID:

Parent Item:

D350-766-021

Parent Item Name:

Interior Protector (Aft Baggage Protector)

CR3213-4-02 CHERRY RIVET

Purchased

Purchased

No

No

Start Date: 11/13/2012

Required Date: 11/22/2012

Start Oty: 2.00-1

Required Qty: 2.00

Purchased

No

Location ST332

116022

110

110

Loc Qty

39 39

Each

Each

1,014.0000

39.0000

Loc Code

Location Loc Qty Loc Code GA 60 121114 60 ST312 626 123164 626 ST330 328 116893 3 116915 120308 100 15

120422 120873

209 110

78.0000

Each

Loc Code Location Loc Oty ST330 50 120521 122378 47 ST332 28 112991 10 116373 18

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	۰ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱ ۱	Date:	
									<u> </u>			QA Closed:	Date:	
Work Ord	ler:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	No.						Rework Scrap			Skid-tube Machining	Crosstube Small Fab	-	Water Jet d. Eng. Coor.	Engineering Quality
NCR	Νo.						Use-as-is Work Order Update	}		noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Des	criț	otion of work order update		Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved														
							F	AUL	T CATE	GORY				
Land	ing (Gear					General					-		7
		Bending Centre No Cracks		ntric to (D/S		Bend BOM/Route Broken/Damaged		1	on Incomplete	() In all and	Ovalized Over/Under Part Incorred	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	-	Crushed/0 Cuffs	crimpea,		-		Burrs Contamination	\vdash	Mainte	ions Incomplete/	Unclear	Part Lost/Mi Part Moved	issing	Iwrong Stock Pulled
	-	Heat Trea	t		ł		Countersink	\vdash	Mislabe			Positioned V	Vrong	
	\vdash	Inspection		Tube	ł		Cut Too Short	\vdash	Misread		<u> </u>	Power Loss/		Other
1.0		Ripples in	-		ļ		Drill Holes		Offset		<u>. </u>		· 0- L	*
		l .	aves in Extrusion Drawing			Out of Calibration								
		Turning Se	eauence		İ	Finish			Out of Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Tuesday, November 13, 2012 10:40:14 AM

Work Order ID:

92992

Parent Item:

D350-766-021

Parent Item Name:

Interior Protector (Aft Baggage Protector)

MS21059L3

Nut Plate

Purchased

Manufactured

No

No

Start Date: 1

227.0000

Start Date: 11/13/2012

Required Date: 11/22/2012

Start Qty: 2-00 /

Required Oty: 2.00

Required

11861412

Locatio	<u>on</u>	Loc Qty		Loc Code
302		10		
	121185	10		
314		3		
	122452	3		
ST301		28		
	118614	8		
	119546	20		
ST302		124		
	120308	13		
	120833	1		
	121444	100		
	121524	10		
ST316		. 62		
	122814	62		
		110	Each	0.0000

110

Each

J 84

2 105 5

500

Plate, Anchor

D3948-043

											DQA:	Date	·
NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORI	MANCE / UPI	DATE	QA Closed:	 Date	
Work Ord	er:	,				DISPOSITION		·	,	AGAINST DI	EPARTMENT,		
Part	No.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	⊣	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR	No.					Work Order Update]		Large Fab	Composite]	Supplier	
Root Cause		Date	Step	e Qty	l	ption of work order update or Non-conformance	1	nitial iief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
oc/Data puip/Tooling perator laterial etup ther rocess upplier laining													
						F	AUL	T CATE	GORY				
Landi		Gear Bending Centre No Cracks Crushed/C Cuffs Heat Treat	Crimped.	ntric to (o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		i '	on Incomplete ions Incomplete/U nance	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Inspection		Tube		Cut Too Short		Misread			Power Loss/		Other
	<u> </u>		Drill Holes		Offset		-						
		Torque W		xtrusio	ı	Drawing		ł	Calibration				
		Turning Se				Finish		1	Sequence				
	Wave/Twist in Tube Folio			Folio	Outside Dimensions								

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REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D350-766

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4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Interior Trim Kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LA'	TERAL	LONGITUDINAL		
mstanation	Weight	Arm	Moment	Arm	Moment	
D350-766-011 Interior Trim Kit (Aft Bulkhead Trim Kit)	13.2 lb	0 in	0 in-lb	113 in	1492 in-lb	
	6.0 kg	0 m	0 m-kg	2.87 m	17.2 m-kg	
D350-766-013 Interior Trim Kit	11.0 lb	0 in	0 in-lb	91 in	1001 in-lb	
(Ceiling Trim Kit)	5.0 kg	0 m	0 m-kg	2.31 m	11.6 m-kg	
D350-766-015 Interior Trim Kit	5.2 lb	0 in	0 in-lb	42 in	218 in-lb	
(Canopy Post Trim Kit)	2.4 kg	0 m	0 m-kg	1.07 m	2.6 m-kg	
D350-766-021 Interior Protector Kit (Aft Baggage Protector Kit)	14.3 lb	2.77 in	39.6 in-kg	168 in	2402 in-lb	
	6.5 kg	0.07 m	0.46 m-kg	4.27 m	27.8 m-kg	

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty (-021	Part Number	Description
Х			-	D350-766-011	INTERIOR TRIM KIT (AFT BULKHEAD TRIM KIT)
	X			D350-766-013	INTERIOR TRIM KIT (CEILING TRIM KIT)
		Х		D350-766-015	INTERIOR TRIM KIT (CANOPY POST TRIM KIT)
			X	D350-766-021	INTERIOR PROTECTOR KIT
					(AFT BAGGAGE PROTECTOR KIT)
			<u> </u>		
1			<u> </u>	D3655-1	PANEL
1				D3655-3	PANEL
	1			D3656-1	PANEL
	1		-	D3656-3	PANEL
			1		=PANEL, FLOOR: 4
					*PANEL, WALL
				-D3 <u>8</u> 91-041	PANEL, FWD-LH-
				^D3891-042	PANEL, EWD RH
				D3944-1	-RLACARD -
			C47	D3945-041	*BRACKET
L		1	İ	D3946-1	PANEL, CENTER POST
		1		D3947-1	PANEL, UPPER LH POST
		1		D3947-2	PANEL, UPPER RH POST
		1		D3947-3	PANEL, LOWER LH POST
		1		D3947-4	PANEL, LOWER RH POST
				=D3948=041 ====	=PLATE, ANCHOR
		L	C4 ==	-D3948-043	::PLATE;ANCHOR
	·				
				-AN525-10R7	
			43	=AN525=10R9===	-SCREW-
2				AN526-1032R12	SCREW
2				AN526-1032R20	SCREW
	15			AN526-1032R9	SCREW
			<u>⊂8</u>	-CCR264SS3-2==	=RIVET===
	30			CCR264SS3-3	RIVET
8				CCR274SS3=4-	-RIVET
				CR3213-4-02	-RIVET_(OR M7885/2_4-02))
		Ĺ		CR3523-4-02	_RIVET_(OR:M7885/4=4=02)
	İ		16	"CR3523-4-03	RIVET (OR M7885/4-4-03)
4	15			-MS21059L3_	NUTPLATE (OR MS21059-3)

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Revision: C

Date: 09.06.08